

Date: Wednesday, 10/25/2006 11:13:50 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY - UNDER REVIEW
Job Number : 29157	
Estimate Number : 10334	
P.O. Number : N/A	Part Number : D2804042
This Issue : 10/25/2006 S.O. No. : N/A	Drawing Number : D2804 REV B Rev C Preliminary Issue
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : R & D SM/MED FAB	Drawing Revision : UNDER REVIEW OK 06/10/25
Previous Run : 27284	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 11/1/2006 Qty: 78 Um: Each
Checked & Approved By : <i>[Signature]</i> 06/10/25	
Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D28042	STA 155 Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

STA 155 Bracket

Pick:

Qty Part Number	Description	Batch
1 D2804-2	Bracket	B 29169

2.0	D28052	Stop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Stop

Pick:

Qty Part Number	Description	Batch
1 D2805-2	Stop	B 29170

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2804

MF.

06/10/30

(2)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB

06/10/30

(7)

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Y

06/10/30

X7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/25/2006 11:13:50 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY - UNDER REVIEW

Job Number: 29157

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press Fit D2809 as per Dwg D2804

MF 06/10/30

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~16~~¹² 0.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt M101064

MF 06/10/30

9.0

D2809

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~8~~⁷ 0.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch

1 D2809 Bushing B 28645

MF 06/10/30

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~16~~¹² 0.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch M100218

2 MS21043-3 Nut M101390

MF 06/10/31

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~32~~²⁸ 0.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch 4 NAS1515H3

Washer

M100993

A/R

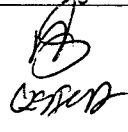
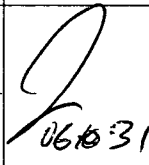
LPS-3

Corrosion Spray

M101472

MF 06/10/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/10/31	12	Applied LPS. Hardcoat on washers & nut B <u>M17045</u>	MF	06/10/31	7		 06/10/31

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 20 Date: 06/11/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

mf. 06/10/30

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/31

(7)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST159

06/10/31 (7)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/01

Job Completion



U 06/11/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

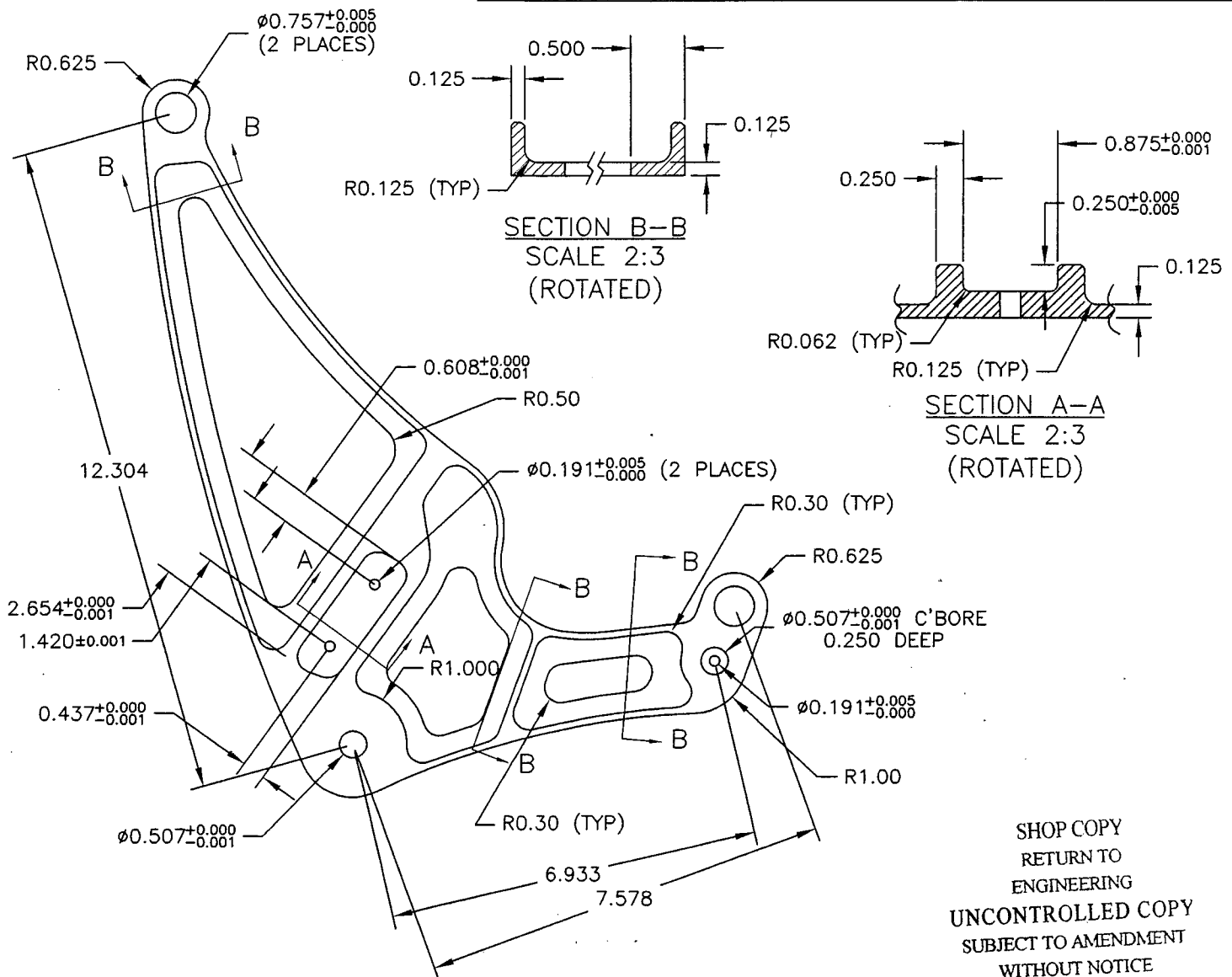
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D2804 REV. C SHEET 1 OF 2
DATE	06.10.16	TITLE	STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE		

PRELIMINARY ISSUE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29157

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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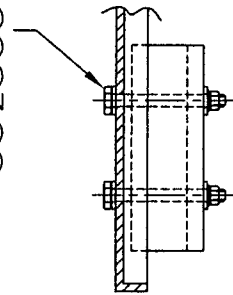
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3

PRELIMINARY ISSUE

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21042-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2804-1 FOR D2804-041/-043
USE D2804-2 FOR D2804-042/-044

USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29157

D2804-041/-043 BRACKET ASS'Y (SHOWN).

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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